

Date: Monday, 09/03/2009 1:42:26 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	: 46333C			Part Number	: D30655		
Estimate Number	: 10382			Drawing Number	: D3065 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 09/03/2009 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 27/03/2009 Qty: 80 Um: Each		
Previous Run	: 45395C						
Written By	:						
Checked & Approved By	: <u>JUL 09 03.09</u>						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF						
	Est Rev:D Now on Water Jet 06-04-11 JLM						
	Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		 Comment: Qty.: 1.1338 sf(s)/Unit Total : 90.7032 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>111003</u> <div style="text-align: right; margin-top: 10px;">   <i>AB 9-3-31</i>  <i>W 09 03 30</i> </div>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <div style="text-align: right; margin-top: 10px;">   <i>AB 9-3-31</i>  <i>09/03/30</i> → <i>Hm</i> <i>(37)</i> </div>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>AB 9-3-31</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <i>AB 9-3-31</i>
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 <i>AB 9-3-31</i>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
		<i>Fx 09/04/01</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:26 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 463336

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



111

Comment: INSPECT CHEMICAL CONVERSION COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl L.

PL 09-04-01  
880964/02 ME

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/02 ME

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	410333C
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

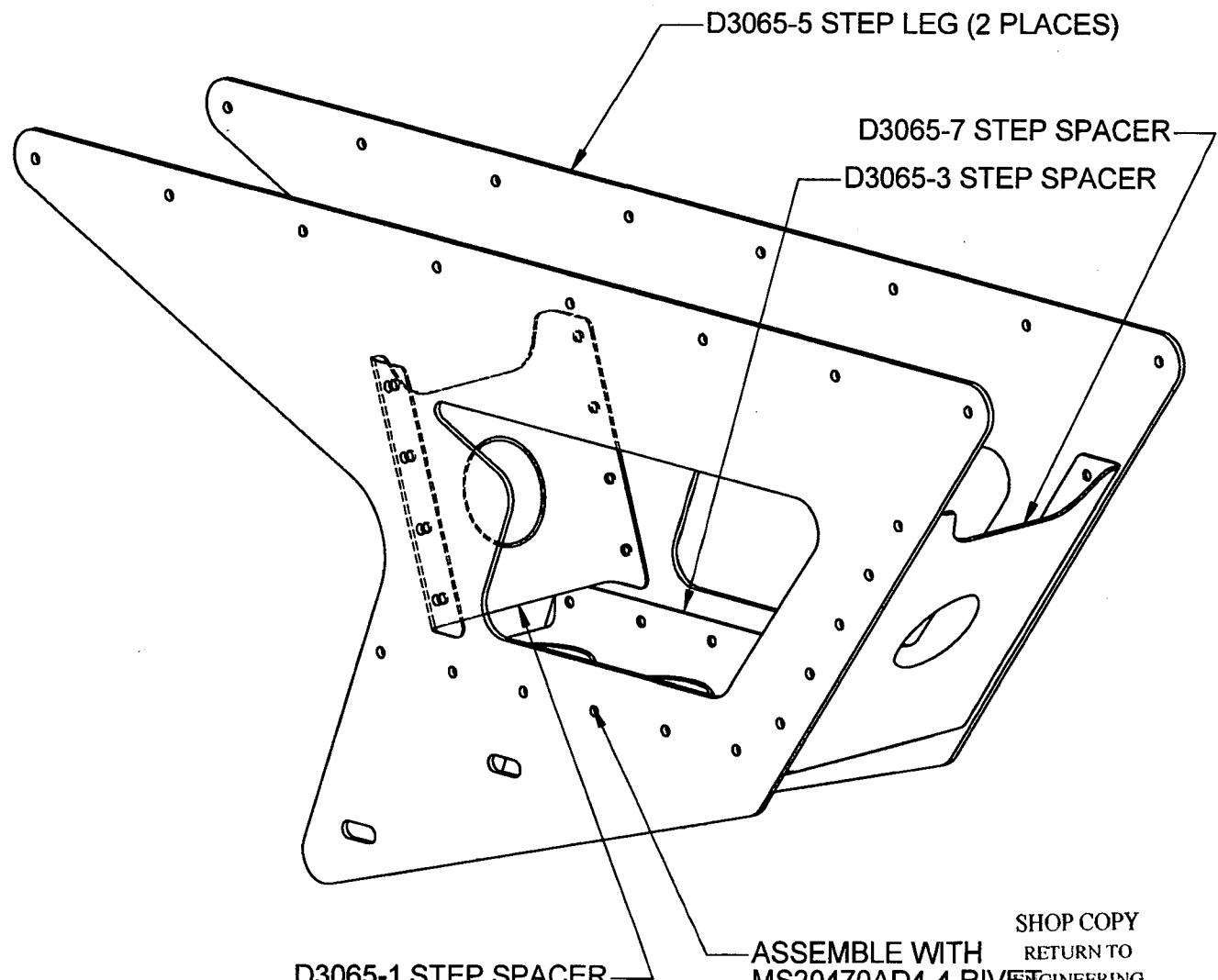
## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>C</u>	Prototype Approval: N/A
Date: 9-3-31	Date: 09/03/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. <b>D3065</b> REV. B SHEET 1 OF 5
DATE	06.05.23	TITLE <b>STEP LEG ASSEMBLY</b> SCALE 1:2
A	02.09.11	NEW ISSUE
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

**RELEASED**06.06.20 ~~CH~~

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**D3065-041 STEP LEG ASSEMBLY**

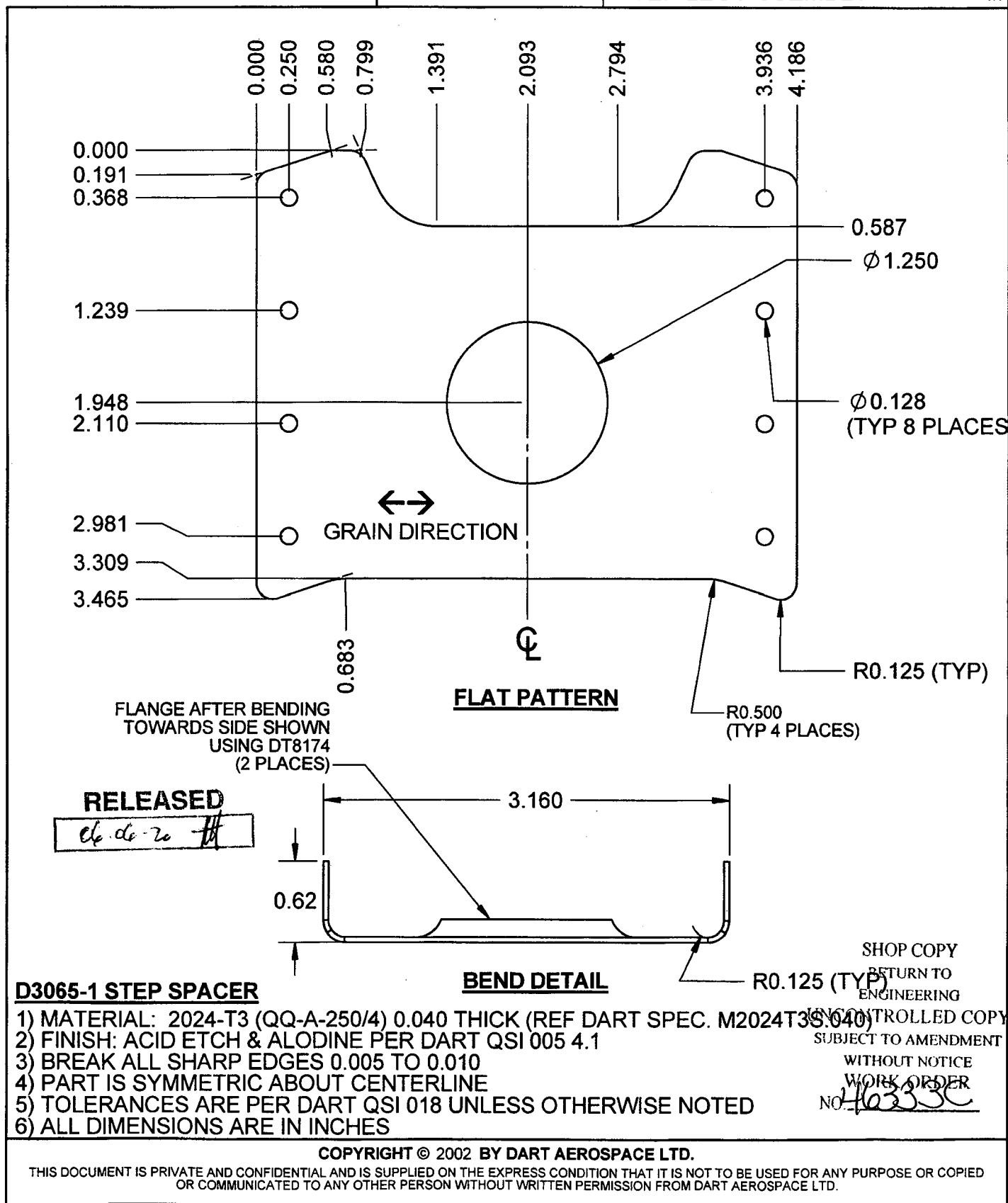
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PH	MM	D3065	REV. B
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY

SHEET 2 OF 5

SCALE  
1:1

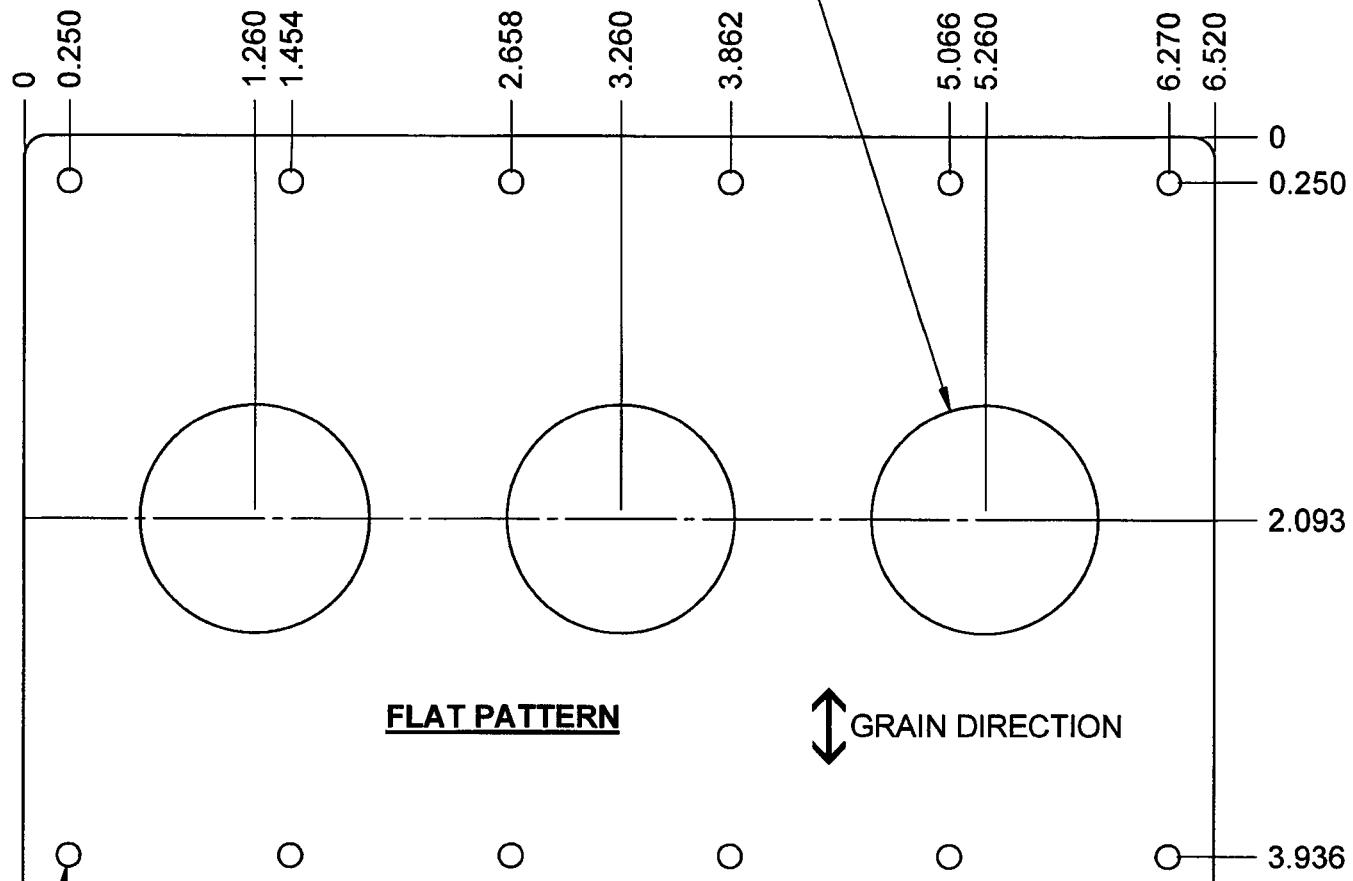
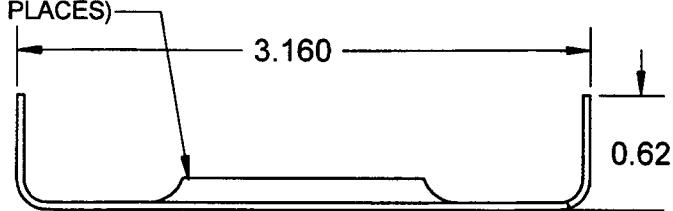
**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>
CHECKED <i>PH</i>	APPROVED <i>M</i>
DATE 06.05.23	

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADADRAWING NO.  
**D3065**

REV. B

SHEET 3 OF 5

SCALE  
1:1TITLE  
**STEP LEG ASSEMBLY** $\phi 1.250$  (TYP, 3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***06.05.23 - M***D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

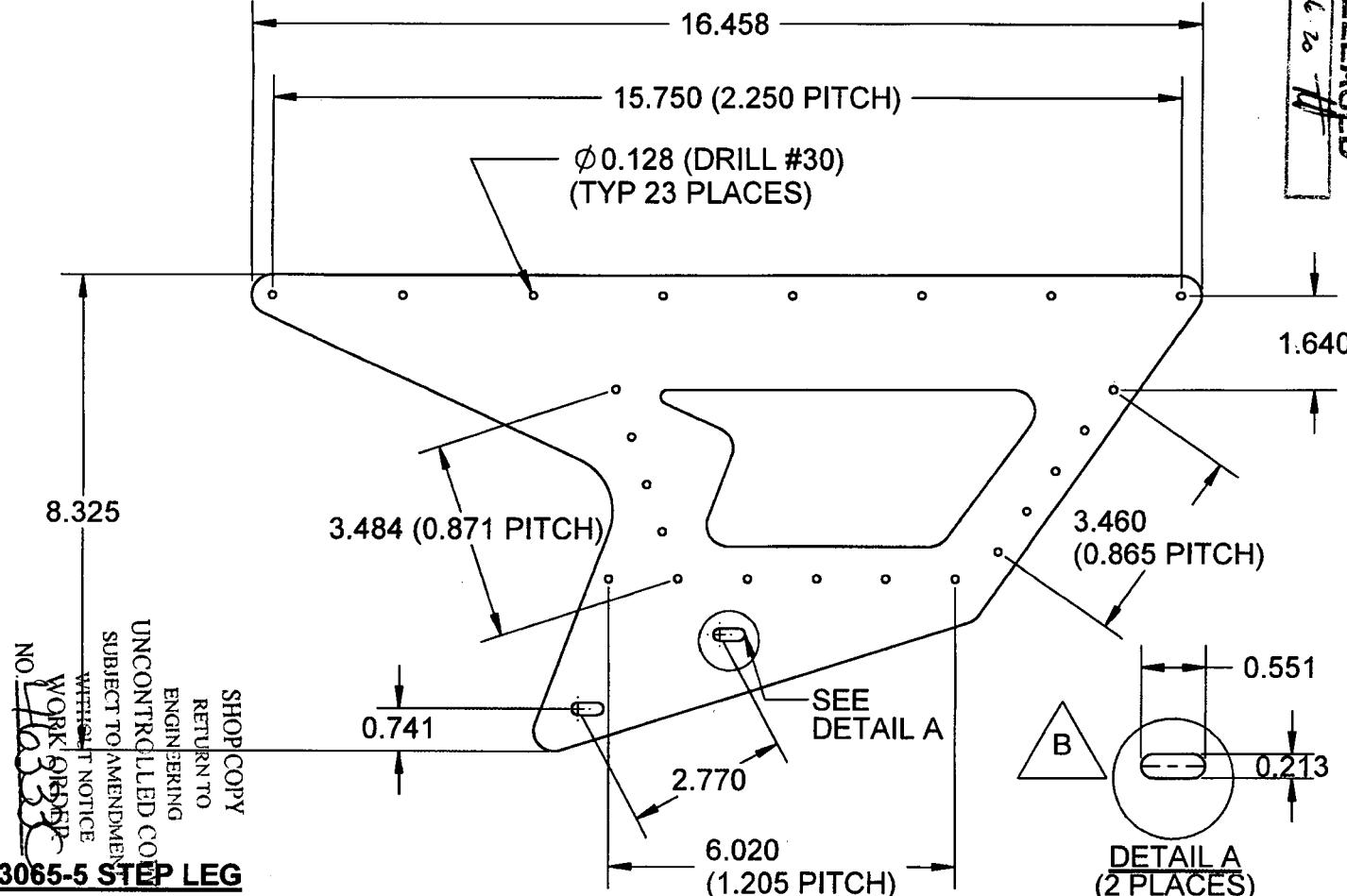
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CHECKED	APPROVED	DRAWING NO.	
PH	H	D3065	REV. B
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY
		SHEET 4 OF 5	SCALE 13

**RELEASED**  
06.06.20 *H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN

DRAWN BY

CHECKED

APPROVED

DATE

06.05.23

IP

CB

PH

MM

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3065

REV. B

SHEET 5 OF 5

SCALE  
1:1